Work Order ID 125922 *125922* Friday, October 24, 2014 2:17:00 PM D3500-1 Accept Item ID: *N900040100* Setup Start **Revision ID:** Stop **Item Name:** Saddle *40* **Start Oty: 40.00 Start Date:** 10/24/14 **Cust Item ID:** Required Date: 11/28/14 Req'd Qty: 40.00 *40* **Customer:** Reference: Run Date: 14-10-26 **Process Plan:** Tooling: Approvals: Date: Stop Date: QC: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ **Tool ID** Tool # Plan Reject Reject Accept Insp. **Work Center ID Description Run Hours** Code Qty Qty Number Stamp Draw Nbr **Revision Nbr** D3500 C DAS 100 0.00 HAAS CNC VERTICAL MACHINING #1 *100* HAAS 1 0.00 Memo DAS 37 14-11.09 Program Batch No. 12592 Double check by: 1-Machine Step No 1 HAAS CNC vertical machine #1 per Folio FA641 and inspect per attached Dimension Sheets2-Machine Step 9-89 No 2 per Folio FA641 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA641 and inspect p DAS 110 QC2- Inspect parts off machine FAI/FAIB 0.00 *110* QC 0.00 Memo

120 QC8- Inspect parts - second check 0.00 OC 0.00 Memo

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Quality Control

Quality Control

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WORK ORDER NON-CONFORMANCE / UPDATE

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ciused:			Date:						, , , , , , , , , , , , , , , , , , , ,	\	Wo	ork Order up	date only		AEROSPACE
Work Orde	or.					DISPOSITION				AGAINST I	DEF	PARTMENT	/PROCESS		
Part N	- ۱٥٠			,		Rework Scrap Use-as-is Suspected Unapproved		ا Therm	Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite			Prod. Eng. Coor. Rec/Store/Packaging			Engineering Quality Other
Root					Descr	ription of work order update	1	nitial	Act	ion	7	Sign &			
Cause	d	Date	Step	Qty	0000	or non-conformance	ľ	ief Eng	Descr			Date	Verificatio	n	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Transport Unapproved	ž.				,										·
		 					FAL	JLT CAT	EGORY						
Landir		Bending Centre No Cracks Crimp/Kin Cuffs Crushing Heat Trea Inspection Marks/Ch Turning Se	nk/Ripple t n Strip in atter	/Wave	1	General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Grain Hardwa Inspecti Instruct Misalig Mislabe Misreac Off-set	on Incomplete/Un ions Incomplete/U ned/off center led	· +		Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	tolerance ct ssing Vrong		Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other
	$\overline{}$	Wave/Tw		e		Fit/Function	ш		equence		-		· · · · · · · · · · · · · · · · · · ·		

Work Orde Friday, October				*125	5922*		,					Page	2
Revision ID:	D3500-1 Saddle			Accept	*N900	040	100	ን* ፡	Setup S	Start Stop		S1*	
Start Date: Required Date: Reference:	10/24/14 11/28/14	Start Qty: 40.00 Req'd Qty: 40.00	*40* *40*		Cust Item I Customer:	D:							
Approvals:	Process Pla	n:	Date:	Tooling: SPC (Y/N):		ate:		F		Start Stop		R1* R <i>2</i> *	
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rejec Qty		leject lumber	Insp. Stamp	
*130 *130* HandFinish Hand Finishing		Chemical Conversion Co. Memo	at per QSI005 4.1	0.00				40	Ø	/2	4-/1-	<u> 24.</u>	9
140 *1 1 1 1 * Powdercoat Powder Coating		White Gloss(Ref:4.3.5.1) White Gloss(Ref:4.3.5.1) Memo START TIM	per QSI005 4.3-Alum 8 • E: <u>0:45 •</u> FINISH TIME:	0.00 0.00 OVEN TEMPERATURE	D:			16.	6	<i> </i> \/	· <i>12</i> · <i>1</i>	·	8 8 8
150		QC3- Inspect Part Finish		0.00			/	(up)			DAS 38 9-89	

0.00

Memo

DEC 0 1 2014

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Quality Control

DQA:			Date:										
•						WORK ORDER NON-	-C(ONFO	RMANCE / UP	PDATE			A E R O S P A C E
QA Closed:			Date:						•	W	ork Order up	odate only	
Work Orde	er:					DISPOSITION				AGAINST DI	PARTMENT	/PROCESS	
						Rework			Skid-tube	Crosstube	7	Water Jet	Engineering
Part I	10.					Scrap		ı	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
						Use-as-is		Thern	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR 1	Ю.					Suspected Unapproved			Large Fab	Composite		Supplier	
Root					Desc	ription of work order update	1	nitial	Acti	on	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	ption	Date	Verification	QC Inspector
Design													
Doc/Data													
Equip/Tooling													
Handling/Pre													
Material				!									
Operator	_												
Offset/Setup													
Process													
Supplier													
Training .													
Transport Unapproved									·				
Unapproved											1		
						14. 1 Jun 1	FAI	ULT CAT	regory				
Landi	ng (1				General	_	1- 1: /5		_	٦٥٠٠٠		7
		Bending			-	Bend	-	•	rogram	-	Outside Dim		Pressure/Forced
		Centre No	ot Concen	itric	-	BOM/Route		Grain			Over/Under		Set-up
		Cracks	1 /D: 1			Broken/Damage/Defect	-	Hardwa			Part Incorred	 	Temperature/Cure
		Crimp/Kin	ik/Rippie,	/wave	-	Burrs	<u> </u>	1	ion Incomplete/Un	 	Part Lost/Mi	ssing	Weld
, a .	Λ.	Cuffs			<u> </u>	Contamination	$\overline{}$	4	ions Incomplete/U	nciear	Part Moved		Wrong Stock Pulled
		Crushing	ı		-	Countersink	<u> </u>	1	ned/off center	<u> </u>	Positioned V]
		Heat Trea		Tub-	<u> </u>	Cut Too Short	\vdash	Mislabe		L	Power Loss/	Surge	Other
		Inspection		eauı		Drawing		Misread					-
		Marks/Ch			-	Drill Holes	<u> </u>	Off-set				· · · · · · · · · · · · · · · · · · ·	
		Turning So		_	\vdash	Finish	<u> </u>	4	Calibration				·
		Wave/Tw	ist in Tub	e		Fit/Function		Jour of S	Sequence				

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Work Ord Friday, October							Page 3					
Item ID: Revision ID: Item Name:	D3500-1 Saddle			Accept	*N900	040	100)* s	-	Start Stop	171	S1* S2*
Start Date: Required Date Reference:	10/24/14 : 11/28/14	Start Qty: 40.00 Req'd Qty: 40.00	*40* *40*		Cust Item I Customer:	D:				S 44		
Approvals:	Process P	·	Date:	Tooling: SPC (Y/N):		nte:		K		Start Stop	"1/1	R1* R2*
Sequence ID/ Work Center I 160 *160* Packaging Packaging	D	Operation Description Identify as per dwg & Sto	ck Location: 5	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Reje Qty		Reject Number DAS 26 9-89	Insp. Stamp DEC () \$2000

170

170

Memo

QC21- Final Inspection - Work Order Release

0.00

0.00

Quality Control

14/12/39) 14/12/39)

DQA: .			Date:						_				DART
QA Closed:			Date:			WORK ORDER NON-	-C(ONFO	RMANCE / U		Work Order uj	adata only	AEROSPACE
QA Closed.			Date.				-	ſ		· · · · · · · · · · · · · · · · · · ·	Work Order up	date only	
Work Ord	er:					DISPOSITION				AGAINST [DEPARTMENT	/PROCESS	
	•		'			Rework			Skid-tube	Crosstube		Water Jet	Engineering
Part I	۷o.					Scrap]		Machining	Small Fab		d. Eng. Coor.	Quality
						Use-as-is			noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR I	Vo.			-		Suspected Unapproved]		Large Fab	Composite		Supplier	
Root					Desc	ription of work order update		Initial	А	ction	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Des	cription	Date	Verification	QC Inspector
Design													
Doc/Data													
Equip/Tooling													
Handling/Pre													
Material													
Operator		*,					1						
Offset/Setup													
Process	<u> </u>												
Supplier													
Training													
Transport							}						
Unapproved							<u>l </u>		<u> </u>			<u> </u>	
	_					· · · · · · · · · · · · · · · · · · ·	FA	ULT CAT	regory				
Landi	ng (1			r	General	_	1		Г		_	
		Bending			-	Bend	-	1	rogram	-	Outside Dim		Pressure/Forced
-	<u> </u>	Centre No	ot Concer	ntric	\vdash	BOM/Route	<u> </u>	Grain		-	Over/Under	├	Set-up
	<u> </u>	Cracks			-	Broken/Damage/Defect	<u> </u>	Hardwa			Part Incorre	⊢	Temperature/Cure
		Crimp/Kir	k/Ripple	/Wave	<u> </u>	Burrs	<u> </u>	1	ion Incomplete/	· ·	Part Lost/M		Weld
	<u> </u>	Cuffs			-	Contamination	<u> </u>	4	ions Incomplete	<u></u>	Part Moved	<u> </u>	Wrong Stock Pulled
		Crushing			_	Countersink	_	4 -	ned/off center	r -	Positioned V		-
	_	Heat Trea			-	Cut Too Short	<u> </u>	Mislabe		Ĺ	Power Loss/	Surge	Other
	<u> </u>	Inspection		Tube	\vdash	Drawing	<u> </u>	Misread					
	<u> </u>	Marks/Ch				Drill Holes	\vdash	Off-set					
	Turning Sequence			Finish	<u> </u>	1	Calibration		**************************************				
	l	Wave/Tw	ist in Tub	e		Fit/Function	1	Out of S	Sequence				

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Work Order ID: 125922

Parent Item: D3500-1

Parent Item Name: Saddle

125922

D3500-1

Start Date: 10/24/14

Required Date: 11/28/14

Start Qty: 40.00

Required Qty: 40.00

Comments:

IPP Rev:A New Issue 06-06-15 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Tota Qty	d Qty Issued	Date Issued	Status
D6102-013	-	Manufactured	No			100	Each	108.0000	1	40	DAS		
D6102-0	13								**		44 14	11/05	

Saddle Billet

Loc Qty	Loc Code	
32		
22		_22
10		
20		
20		
20		
20		
36		
10		
6		6
8		8
12		<u> </u>
	32 22 10 20 20 20 20 36 10 6 8	32 22 10 20 20 20 20 36 10 6

Page 1

DQA:	Date:															
						WORK ORDER NON-	-CC	ONFO	RMANCE / L	JPDATE			AERÓSPACE			
QA Closed:			Date:							W	ork Order up	date only				
Work Ord	er:					DISPOSITION				AGAINST DE	DEPARTMENT/PROCESS					
Part I						Rework Scrap Use-as-is Suspected Unapproved	Scrap Use-as-is Thern Dected Unapproved			Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Rec Large Fab Composite			Water Jet Engineering Prod. Eng. Coor. Quality ec/Store/Packaging Supplier			
Root					Desc	ription of work order update	Ī	nitial	A	ction	Sign &					
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Des	cription	Date	Verification	n QC Inspector			
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved		₹		•						,						
		l	l	<u> </u>	l		FAI	ULT CAT	regory		1					
Landi	ng (Gear				General										
		Bending Centre No Cracks				Bend BOM/Route Broken/Damage/Defect	-	Folio/P Grain Hardwa	Program		Outside Dim Over/Under Part Incorred	tolerance	Pressure/Forced Set-up Temperature/Cure			
	_	Crimp/Kin	k/Ripple	/Wave	<u> </u>	Burrs		1 `	ion Incomplete/l	 	Part Lost/Mi	· ·	Weld			
	_	Cuffs			-	Contamination		1	tions Incomplete		Part Moved		Wrong Stock Pulled			
	_	Crushing			<u> </u>	Countersink		1 -	gned/off center	·	Positioned V	Ŭ r	Othor			
		Heat Trea Inspection		Tubo		Cut Too Short Drawing	-	Mislabe Misread		L	Power Loss/	ourge [Other			
		Marks/Ch		rupe		Drill Holes	_	Off-set								
		Turning Se				Finish	\vdash	4	Calibration							
		Wave/Tw		e		Fit/Function		4	Sequence							

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

DART AEROSPACE LTD	Work Order:	125922
Description: Saddle	Part Number:	D3500-1
Inspection Dwg: D3500 Rev: C		Page 1 of 1

								20 . 0	
				Re	corded Act	ual Dimensi	ons		
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	Ву	Date
Α	0.483	0.490		E484	.484	u484	0484		
В	1.175	1.185	<u> </u>	1,180	10810	1.180	1.180		
С	3.145	3.155		3, 150	3,150	3.150	3,150		
D	1.175	1.185		1.180	1.180	1,180	1.180		
E	0.365	0.385		•376	6317	377	376		
F	0.490	0.510		*200	500	.499	.499		
Н	-			1		. 4-7	1.411		
V .		· · · · · · · · · · · · · · · · · · ·	(Note:	Dimension	l is 0.015" o	ver flange)		1 1	
ī	R1.575	R1.595	(11010)	1,5865	1,586	1.5865	1.586	1	
J	0.240	0.260	·	.250	·249	.750	750	-	
K	0.490	0.510		<u>0,500</u>	,500	. 499	.500		
L	3.590	3.650		3,60	3,620	3,620	3,620		
М	0.315	0.322		0316	.316	.36	-316		
N	0.256	0.262		ે ટેડી	253	.257	~257		· ,
0	6.500	6.520		4,510	6.510	6.510	6.510		
Р	5.990	6.010		6.000	5.999	6.001	6.001		
Q	2.820	2.830		2.825	2,825	2,825	2.825		
R	2.495	2.505		2,500	2.500	₹.5∞	2.500		
S	2.245	2.255		2.250	2,250	2.280	2,250		
T	1.120	1.130		1.125	1.125	1-125	1,125		
Ü	0.540	0.560		,550	:550	.550	.550		
V	0.793	0.803		798	.798	798	.798		
W	R.240	R.260		. 250	,250	6 ZSO	. 5 20		
Х	0.040	0.060		.050	.050	2 CS0	,050		
Υ	0.100	0.120		. 11O	-110	0110	0110		
AA	R1.125	R1.145		1.132	10132	1925	1.132.		
AB	R.490	R.510		S&0	_a SON	ु ५००	" 2లు		
AC	0.615	0.635		.625	. 675	625	.625		
AD	0.240	0.260		.254	.256	.756	. 756		<u> </u>
AE	1.810	1.830		1.820	10812	1.819	1.820		
AF	0.240	0.260		, S <u>2</u> ,0	251	,750	. 250		
AG	0.140	0.160		.150	150	.150	.150		
AH	0.140	0.160		0152	0151	.151	121		
Al	0.140	0.160		e/52.	-153	. 157.	1152.		
	Acce	pt/Reject	DAS		7		<u></u>		

		37		1	
Measured by:	FX.	9-89	Audited by	and,	
Date:	14/11/05	14.11.06	Date:	14/11/24	

Rev	Date	Change	Revised by	Approved
Α	06.09.26	New Issue	KJ/EC	
В	08.10.07	Dimension H removed	KJ/DD	
С	08.11.28	Dimension 'M' revised	KJ/EC \ \	11
D	11.01.17	Note added to Dim I	KJ SK	22

3.

DAR	T AEROS	PACE L	ΓD			Wo	rk Order:	_/	25922
Descr	iption: Sad	idle			<u>. </u>	Pa	rt Number:		D3500-1
Inspe	ction Dwg:	D3500	Rev:	C			<u>:</u>	Pa	age 1 of 1
				Re	corded Actu	ual Dimensi	ons		
Dim	Min	Max	Go/No Go Gauge	*	6	*	8	Ву	Date
Α	0.483	0.490		2489	.484	.484	.484		
В	1.175	1.185		1,180	1./80	1.180	1.180		
С	3.145	3.155		3,(50	3,50	3.150	3.150		
D	1.175	1.185		1 - 180	1.120	1.180	1.180		
Е	0.365	0.385		.377	375	375	.375		
F	0.490	0.510		.500	. 497	3499	: 500		
Н				<u> </u>	/				<u> </u>
1	D.4 M-72	54.505	(Note		l is 0.015" o				
_ ! _	R1.575	R1.595		1.586	.1586		7.586		
J	0.240	0.260	<u> </u>	. 250	. 251	248			
K	0.490	0.510		501	3.620	.500	3630		
<u> </u>	3.590	3.650		3.620		3.620	3.620		-
M	0.315	0.322		-316	.3/6	3/6	.3/6		·
N	0.256	0.262	-	F25.	253	7257	6.510		
0	6.500	6.520		\$.570	6.511	6.511			
P	5.990	6.010		6.001	6.000	6.001	2.825		
Q	2.820	2.830		5.855	2.525	2.825			
R	2.495	2.505		2-500	3.800	2.500	2.250		
S	2.245	2.255		2.250	2.750	2.250			
T	1.120	1.130		1549	1.125	1.125	1.125		
U	0.540	0.560	<u> </u>	1397		:549 .778	798		
V	0.793	0.803		250	798	.250	. 770		
W	R.240	R.260			520	· · · · · · · · · · · · · · · · · · ·	680		-
X	0.040 0.100	0.060 0.120		.050	.110	1620	611.		
-	0.100	0.120		0110	1.10	100	-,1(0		
AA	R1.125	R1.145		1.130	1.131	1.132	1.133		
AB	R.490	R.510		2500	5€0	,500	,500		
AC	0.615	0.635		.625	1625	625	.625	····	T
AD	0.013	0.260		.754	1254	. ब्रुडचे	.255		1
AE	1.810	1.830		1,820	1.670		1.820		
AF	0.240	0.260		152.	,250	1251	281		
AG	0.140	0.160		.121	.750	.150	150		
AH	0.140	0.160		.151	.150	. 150	130		
Al	0.140	0.160		157	.151	.151	.149		
r 11	<u> </u>	0.,00							
	Acce	pt/Reject			-	/			
			DAS			174	- /3) · /	,	
Me	asured by:	FK.	37		A	udited by	ang	1011	
	Date:	14/11/09	5 9-ES(11.06		Date:	14/11/	24	
Rev	Date	Chang	je				Revised	l by	Approved
A	06.09.26						KJ/EC		
В	08.10.07		sion H rem	oved			KJ/DD		
C									
Ď	11.01.1		dded to Dir		1		KJ	X	212

S.

DART AEROSPACE LT	'D	Work Order:	128922	
			:	
Description: Saddle			Part Number:	D3500-1
Inspection Dwg: D3500	Rev: C			Page 1 of 1

				Red	corded Actu	ıal Dimensi	ons		
Dim	Min	Max	Go/No Go Gauge	9	10	3	12	Ву	Date
Α	0.483	0.490		.484	2484	. 484	. 484		
B	1.175	1.185		1.180	1.189	1:180	1.180		
C	3.145	3.155		3150	3.150		3.150		
Ď	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.375	.375	.375	.375		
 F	0.490	0.510		149	.499	501	199		
H	0.100	0.010							
	<u> </u>	l	(Note:	Dimension	is 0.015" o	ver flange)	:		
<u> </u>	R1.575	R1.595		-auto	1.589	1.589	1.587		
j	0.240	0.260		246	.146	.247	.249		
K	0.490	0.510		.501	. 500	.501	500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		.316	,3/6	.3/6	.316		
N	0.256	0.262		1257	.257		.257		•
0	6.500	6.520		6.510	6.511	6.570	6.511		
P	5.990	6.010		6.005	6.001	6.003	6.007		
Q	2.820	2.830		2.885	7.885	2895	3.885		
R	2.495	2.505		2.500	3.500	2500	2.500		
S	2.245	2.255		2.250	2.250	250	3.250		
Ŧ	1.120	1.130		1.125 -	1.125	1.125	1.125		
U	0.540	0.560		,550	. 549	.550	. 551		
V	0.793	0.803		. 793	.798	.798	. 798		
W	R.240	R.260		.250	, 250	,520	, 250		
X	0.040	0.060		.050	. 050	1050	. ८५७		
Y	0.100	0.120	-	-110	01)	.110	011		
AA	R1.125	R1.145		1.132	134	1.132	1.133		
AB	R.490	R.510	-	.500	, seo	,500	,500		
AC	0.615	0.635		.625	.625	.625	.622		
AD	0.240	0.260		:750	.251	. 250	. 751		· · ·
AE	1.810	1.830		1.833	1.621	. 1821	1823		
AF	0.240	0.260		:251	.249	.250	. 249		
AG	0.140	0.160		3149	.151	. 154	,150		*
AH	0.140	0.160		149	151	. 151	. 149		
Al	0.140	0.160		.151	. 150	. 149	. 150.		,
	<u> </u>					1			
	Acce	pt/Reject		.,	-	_			હૃં.
		·······································							

A=	,			
Measured by: 0.80		Audited by	CM	
Date: 14.11:00		Date:	14/11/24	

Rev	Date	Change	Revised by	Approved
A.	06.09.26	New Issue	KJ/EC	
В	08.10.07	Dimension H removed	KJ/DD	
С	08.11.28	Dimension 'M' revised	KJ/EC , \	1.
D	11.01.17	Note added to Dim I	KJ 9	<u> </u>
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DART AEROSPACE LTI	D	:	Work Order:	125922
Description: Saddle			Part Number:	D3500-1
Description. Saudie				
Inspection Dwg: D3500	Rev: C			Page 1 of 1

				Red					
Dim	Min	Max	Go/No Go Gauge	13	14	15	16	Ву	Date
Α	0.483	0.490		.484	484	.484	.484		
В	1.175	1.185		1.180	1.180	1.180	1.180		
С	3.145	3.155		3.150	3.150	3150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
Ε	0.365	0.385		.375	.375	.375	. 375		
F	0.490	0.510		499	500	.499	.498		
Н									
			(Note:	Dimension	is 0.015" o	ver flange)			
	R1.575	R1.595		1.588	1.587	1.586	1.590		
J	0.240	0.260		246	, 245	. 245-	: 246		
K	0.490	0.510		. క్య	. 502	.503	. 501		
L	3.590	3.650		3.620	3.600	3.620	3.620		
М	0.315	0.322		.316	. 316	. 316	.316		
N	0.256	0.262		1257	. 257	. 757	· 25 7		
0	6.500	6.520		6.510	6.508	6.509	6.510		
Р	5.990	6.010		6.001	6.000	6.001	6.001		
Q	2.820	2.830		2.885	3.835	5.632	2.825		
R	2.495	2.505		a, 500	a .500	. 2500	2500		
S	2.245	2.255		2,250	2.250	2.250	2.250		
Т	1.120	1.130		1.125	1.128	1.125	1125		
U	0.540	0.560		,550	.549	.550	545		
V	0.793	0.803		,798	738	.798	.728		
W	R.240	R.260		750	.250	,250	.250		
Х	0.040	0.060		,050	000	.050	.050		
Y	0.100	0.120		u/40	.110	.110	- 110		
AA	R1.125	R1.145		1.133	1.132	1.133	1.132		
AB	R.490	R.510		,500	.500	.500	300		
AC	0.615	0.635		,625	.625	.625	.625		
AD	0.240	0.260		,250	. 25]	. 249	,251		
AE	1.810	1.830		1.825	1.825	1.825	1.825		
AF	0.240	0.260		, 350	. 2619	. 247	.2.51	·	
AG	0.140	0.160		.151	147	149	.151		
AH	0.140	0.160		.150	. 4147	149	. 151		
Al	0.140	0.160		. 149	160	.160	149		
	:				delibert a		:		
	Acce	pt/Reject					سعر:		

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-	Measured by: 0.00	Audited by	200	
	Date: 14-11-07	Date:	14/1/10	24

A 06.09.26 New Issue	KJ/EC	
B 08.10.07 Dimension H removed	KJ/DD	
C 08.11.28 Dimension 'M' revised	KJ/EC \	1.
D 11.01.17 Note added to Dim I	KJ X	

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DART AEROSPACE LTD			Work Order:	125922	
Description: Saddle			Part Number:	D3500-1	
Inspection Dwg: D3500	Rev: C			Page 1 of 1	

				Re	corded Actu	ial Dimensi	ons		
Dim	Min	Max	Go/No Go Gauge	17	18	3-19	70	Ву	Date
Α	0.483	0.490		.484	484	. 484	.484		
В	1.175	1.185		1.180	1.180	1.180	1.180		
С	3.145	3.155		3.150	3.50	3.150	3.150		
D	1.175	1.185		1.180	1.180	1-180	1.180		
Е	0.365	0.385		-375	.375	.375	. 375		
F	0.490	0.510		2499	. 498	,498	499		
Н									
			(Note:	Dimension	i is 0.015" o	ver flange)			, <u></u>
1	R1.575	R1.595		1.580	1.507	1.587	1.586		
J	0.240	0.260		. 251	. হ্মণ	.249	:200		
K	0.490	0.510		500	,499	. 4901	ં શહે		
L	3.590	3.650		3620	3,620	3.670	3.620		
M	0.315	0.322		.316	.316	.316	. 316		
N	0.256	0.262		,257	.357	. 287	.057		
0	6.500	6.520		6.510	6.510	6.510	6509		
Р	5.990	6.010		6-051	6.001	6-001	6.000		
Q	2.820	2.830		2.825	7.825	5.852_	S. &5 2 2		
R	2.495	2.505		2.500	5.500	2.500	5.220		
S	2.245	2.255		2.250	2280	3.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.550	1551	. 54°C	.550		
V	0.793	0.803		·798	.798	798	· 798		
W	R.240	R.260		,250	-250	. 250	.250		
X	0.040	0.060		.050	.050	. 650	020		
Y	0.100	0.120		-110	.1(4	.110	.110		
AA	R1.125	R1.145		2.1.132	1.133	1.132	1.136		
AB	R.490	R.510		,500	.500	,500	- 500		
AC	0.615	0.635		.625	.625	.625	.625.		
AD	0.240	0.260		:250	. 249	125.	.3.21		
AE	1.810	1.830		1.8701	1.821	1.822	1855		
AF	0.240	0.260		. 250	.247	-250	. 250		
AG	0.140	0.160		. [5]	1149	.151	.157		
AH	0.140	0.160		. 151	.151	.149	144		
Al	0.140	0.160		147	.180	.150	150		
	Acce	pt/Reject							
		- 27			,	124	· Oal		

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Measured by: 37		Audited by	only,	
Date: 14.11.07		Date:	14/1/2	4

Rev	Date	Change	Revised by	Approved
Α	06.09.26	New Issue	KJ/EC	
В	08.10.07	Dimension H removed	KJ/DD	
С	08.11.28	Dimension 'M' revised	KJ/EC \	11
D	11.01.17	Note added to Dim I	KJ K	

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DAR	T AEROS	SPACE L	TD			Wo	rk Order:	10	VS922
Desci	ription: Sa	ddle				Pa	rt Number:	D:	3500-1
Inspe	ction Dwg	: D3500	Rev:	C				Pag	e 1 of 1
				Re	corded Actu	ıal Dimensi	ons		
Dim	Min	Max	Go/No Go Gauge	21	22	23	24	Ву	Date
Α	0.483	0.490	"	.484	0484	.484	.484		
В	1.175	1.185		1.180	1.180	1.180	1.190		
С	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
Е	0.365	0.385		.395	.375	375	.375		
F	0.490	0.510		.499	307	. 499	350		
Н				<u> </u>					
	r _	T	(Note		l is 0.015" o				
	R1.575	R1.595		1.590	1.590	1.529	1.589		
_ <u>J</u>	0.240	0.260		.251	. 251	.240	:750		
K	0.490	0.510		. 501	.501	.500	.500		
L	3.590	3.650	•	3.620	3.620	3.620	3.620		
M	0.315	0.322		.3/6	.316	.316	:316		
N	0.256	0.262	·	,257	1257	.757	.257		
<u> </u>	6.500	6.520		6.571	6.570		6.510		
Р	5.990	6.010		5.997	5.998	5.999	6.000		
Q	2.820	2.830		2.825	2.025	7-825	7.525		
R	2.495	2.505		2.500	2500	2.500	2.500		
S	2.245	2.255		2, 750	7.280	2.250	2.250		
Ţ	1.120	1.130		1.125	1.1125	1.125	1.125		
U	0.540	0.560		.550	. 549	.551	.550		
V	0.793	0.803		: 798	,798	.798	798		
W	R.240	R.260		.250	, 250	.250	-250		
X	0.040	0.060		. 050	.080	1070	·055		
Y	0.100	0.120		210	.110	110	.110		
Α Δ	D4 405	D4 445		1 100	1.0	1.137	1 12 8		
AA	R1.125	R1.145		1.138	1.137		1.138		
AB	R.490	R.510		,500	, 5200	·800	.800		

Accept/Reject DAS Measured by: Audited by 37 Date: Date: 14.89.8

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1.620

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.151

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1.820

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1822

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.149

625

1.820

250

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150

.149

250

	Rev	Date	Change	: 4	Revised by	Approved
T	Α	06.09.26	New Issue	·	KJ/EC	
Γ	В	08.10.07	Dimension H removed	:	KJ/DD	
	С	08.11.28	Dimension 'M' revised		KJ/EC \	
٦	D	11.01.17	Note added to Dim I		KU XX	SIA
-				. 1		

AC

AD

AE

AF

AG

AH

Αl

0.615

0.240

1.810

0.240

0.140

0.140

0.140

0.635

0.260

1.830

0.260

0.160

0.160

0.160

DART AEROSPACE LT	D	Work Order:	125922
Description: Saddle		Part Number:	D3500-1
		;	
Inspection Dwg: D3500	Rev: C		Page 1 of 1

				Red	corded Actu	ual Dimensi	ons		
Dim	Min	Max	Go/No Go Gauge	25	7 2 W	3	74	Ву	Date
Α	0.483	0.490		484	-484	484	. 484		
В	1.175	1.185		1-140	1.180	1.180	1.180		
С	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1./80	1.160	1-180	1.180		
Е	0.365	0.385		.375	.375	. 373	.378		
F	0.490	0.510		.499	500	. 499	.498		
Н					1	,			
			(Note:	Dimension	l is 0.015" o				
ı	R1.575	R1.595		1.590	1.590	1.589	1.5885		
J	0.240	0.260		.249	. २५७	.751	1.250		
K	0.490	0.510		.500	. 500	.501	.501		
L	3.590	3.650		3.620	3.620	3.620	3.620		
М	0.315	0.322		.3/6	.316	.316	.316		
N	0.256	0.262		,257	· 257	.25A	.257		
0	6.500	6.520		6.510	6.510	6.509	6.509		
P	5.990	6.010		7.875	6.000	6.0015	6.001		
Q	2.820	2.830		7.825	3.825	2.825	2.825		
R	2.495	2.505		2,500	2500				
S	2.245	2.255		2.2.50					
T	1.120	1.130		1,175	11125	1.125	1.155		
U	0.540	0.560		1851	-550	.549	548		
V	0.793	0.803		·79B	798	.738	.798		
W	R.240	R.260		.250	.250	,250	250		
Х	0.040	0.060		.650	.050	~C2.0	.050		
Υ	0.100	0.120		-J/O	J/0	3110	./10		
					4				
AA	R1.125	R1.145		1.137	1.136	1.1385	1.137		
AB	R.490	R.510		.500	.500	-200	500		
AC	0.615	0.635		.625	.b25°	.625	.625		
AD	0.240	0.260		. 252	. 252	.280	. 251		
ΑE	1.810	1.830		1.820	1.820	1.620	1.820		
AF	0.240	0.260		. 247	350	,249	.249		
AG	0.140	0.160		.149	. 149	.148	1148		
AH	0.140	0.160		.149	-M9	1/49	,148		
Al	0.140	0.160		.151	021.	157	182		
	Acce	pt/Reject			<u> </u>		. —		

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Measured by: 0.80	Audited by
Date: 14.11.08	Date: 14/11/24
	

Rev	Date	Change	Revised by	Approved
Α	06.09.26	New Issue	KJ/EC	
В	08.10.07	Dimension H removed	KJ/DD	
С	08.11.28	Dimension 'M' revised	KJ/EC \	1.
D	11.01.17	Note added to Dim I	KJ 🛠	AK)

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DART AEROSPACE LT	DART AEROSPACE LTD			125922
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Description: Saddle			Part Number:	D3500-1
		: 1		
Inspection Dwg: D3500	Rev: C			Page 1 of 1

				Red	corded Actu	ıal Dimensi	ons		
Dim	Min	Max	Go/No Go Gauge	1	2	3	4 32	Ву	Date
	0.483	0.490	Cauge	29	30	3(. 484		
A B	1.175	1.185	 	.484	1.180	1.180	1.180	 	
C				1.180		3.150	3.160	<u> </u>	
	3.145	3.155		3.150	3.150				
D	1.175	1.185		1.180	1.180	1./80	1.180		
E	0.365	0.385		.375	.335	39-5	. 375		
F	0.490	0.510	<u> </u>	,4995	499	:506	6499		
Н			/ * * * * * * * * * * * * * * * * * * *		1 0 045"		L	t	L
<u> </u>	54.555	54.505	(Note:		l is 0.015" o				1
!	R1.575	R1.595		1.590	1.591	1.590	1.588		
J	0.240	0.260		. 251	. 250	. 256	:749		
K	0.490	0.510		.500	. 500	. 499	. 501		
L	3.590	3.650		3.620	3.620	3.620	3.620		
М	0.315	0.322		, 316	.316	,316	.316		
N	0.256	0.262		, 257	,257	.257	.257		
0	6.500	6.520		6.510	6.511	6.510	6.511		
Р	5.990	6.010		6.001	6.00	6.000	6.001		
Q	2.820	2.830		2.825	2.835	2.885	2.825		
R	2.495	2.505		2.500	2.500	2,500		-	
S	2.245	2.255		2.250	2.20		9.520		
T	1.120	1.130		1.125	1.152	-11125	1.125		
U	0.540	0.560		,550	. 5 47	.550	.548		
V	0.793	0.803		.77B	.756	1799	.798		
W	R.240	R.260		1250	.280	,250	.550		
X	0.040	0.060		, 650	,650	029.	(CS)		
Y	0.100	0.120		, i/O	-110	. j(0	611		
			·				1		
AA	R1.125	R1.145		1.134	1.133	1.134	1/38		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.625	.625	. 625	.625		
AD	0.240	0.260		,249	. 250	. 249	, 25-1		
AE	1.810	1.830		1.820	1.820	1.820	1.820		
AF	0.240	0.260		. 251	. 249	125.	. 250	· ·	
AG	0.140	0.160		.149	.14	.150	.148		
AH	0.140	0.160		.149	.149	.150	, 148		*
Al	0.140	0.160		.150	.15	.151	. 151		
	Acce	pt/Reject				-	~~		
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N	Measured by:	ു.ജ്യ	Audited by	onf.	
	Date:	14.11.08	Date:	14/11/24	

Rev	Date	Change	Revised by	Approved
Α	06.09.26	New Issue	KJ/EC	,
В	08.10.07	Dimension H removed	KJ/DD	
С	08.11.28	Dimension 'M' revised	KJ/EC \	
D	11.01.17	Note added to Dim I	KJ 9XT	SK

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DART AEROSPACE LT	D -		Work Order:	125922
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Description: Saddle			Part Number:	D3500-1
Inspection Dwg: D3500	Rev: C	:		Page 1 of 1

				Re	corded Actu	ıal Dimensi	ons		
Dim	Min	Max	Go/No Go Gauge	33	2	35	4 36	Ву	Date
	0.402	0.400	Juage		34		. 484		
A B	0.483 1.175	0.490	 	.484	.484	.484	1.404		
		1.185		1.180	1-180	1.180	1.130		
C	3.145	3.155		3.150	3.50	3.150	3.180		
D	1.175	1.185		1.180	1.180		1.180		ļ
E	0.365	0.385		.375	.375	.375	. 375		
F	0.490	0.510		501	.502	,501	.500		
Н		L	L	<u> </u>	L			L	<u> </u>
	r 	· - ·	(Note:	Dimension					I
	R1.575	R1.595		1.589	1.589	1.550	1.550		
J	0.240	0.260		.250	25(.251	. 250		
K	0.490	0.510		551	. इद (.500	.459		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		.316	.316	.316	.316		
N	0.256	0.262		.257	257	.357	. 25-4		
0	6.500	6.520		6.510	6.310	6509	6.509		
P	5.990	6.010		6.00	6.000	6.001	6.000		
Q	2.820	2.830		a. 625	7.825	2.625	2.825		
R	2.495	2.505		2.500	,250	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	5.550		
T	1.120	1.130		1.125	1.125	1.175	1.125		
J	0.540	0.560		,551	.549	.550	- 5.051		
V	0.793	0.803		,798	.798	.798	.798		
W	R.240	R.260		-250	. 250	.250	. 250		
X	0.040	0.060		, 680	. 000	.060	.000		
Y	0.100	0.120		.110	21/0	./10	110		
						Line Toronto	1		
AA	R1.125	R1.145		1136	(.136	1.138	1.137		
AB	R.490	R.510		-500	.500	.000	500		
AC	0.615	0.635		.625	25	.625	,625		
AD	0.240	0.260		.251	.249	. 250	. 251		
AE	1.810	1.830		1.520	1.820	1.820	1.820		
AF	0.240	0.260		.249	. 257	580	.249		
AG	0.140	0.160		.149	151	.151	. 144		
AH	0.140	0.160		. (49	. 151	. 15-1	143		
Al	0.140	0.160		.15-1	. 152	152	.15		
71	0.140	0.100		121	, ,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,	. 13 =			
	A 0.00	pt/Reject							
L	ACCE	An Desarr					<u> </u>		

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Measured by: 0.90	- [Audited by	- 1	CM.	
Date: 94.11.09		Date:	÷	14/1/24	
Date. 77. 11. 0	L	Duto.	 -		

Rev	Date	Change	Revised by	Approved
Α	06.09.26	New Issue	KJ/EC	
В	08.10.07	Dimension H removed	KJ/DD	
С	08.11.28	Dimension 'M' revised	KJ/EC , L	1
D	11.01.17	Note added to Dim I	KJ X	SIA

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DART AEROSPACE LT	'D	Work Order:	125922	
Description: Saddle			Part Number:	D3500-1
Inspection Dwg: D3500	Rev: C	· .		Page 1 of 1

				Re	corded Actu	ual Dimensi	ons		
Dim	Min	Max	Go/No Go	4	2	3	4	Ву	Date
			Gauge	37	38	35	40		
A	0.483	0.490		3484	154	.484	. 484		
В	1.175	1.185		1.180	1.180	1.180	1.180		
С	3.145	3.155		3.150	3.100	3:120	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180	 	
E	0.365	0.385		.375	375	.375	.375		
F	0.490	0.510		.501	. 502	500	.501		
Н						<u> </u>	[· · · · · · · · · · · · · · · · · · ·
			(Note:		l is 0.015" o	ver flange)	114 2 2 3		
1	R1.575	R1.595		1.589	1.588	1589	1.590		
J	0.240	0.260		.250	,249	.251	(250)		
K	0.490	0.510		,501	.498	. 499	. 499		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		.316	. 316	.3/6	.316		
N	0.256	0.262		·257	. 257	. 257	-626.		
0	6.500	6.520		6.510	10.570	6.510	6510		
Р	5.990	6.010		6.001	6.000	6,001	6.0005		
Q	2.820	2.830		2.825	7.825	2.825	2.825		
R	2.495	2.505		2.500	7.500	5.500	5.200		
S	2.245	2.255		2.320	2.250	2.250	2.250		
T	1.120	1.130		1,125	1.135	1.175	1.125		
U	0.540	0.560		.550	552	,551	.549		
V	0.793	0.803		. 758	.778	798	.798		
W	R.240	R.260		,250	. 250	. ZSO	.250		
X	0.040	0.060		0.660	.060	.060	.060		
Y	0.100	0.120		, i/ O	.110	.//0	110		
				•	***************************************		T.		
AA	R1.125	R1.145		1.138	1.137	1.136	1.138		
AB	R.490	R.510		,500	500	are,	orso.		
AC	0.615	0.635		.625	.625	.625	.625		
AD	0.240	0.260		, 250	.247	- 249	.251		
AE	1.810	1.830		1-820	1,820	1.920	1.8520		
AF	0.240	0.260		1249	.250	251	. 249		
AG	0.140	0.160		151	150	150	151		
AH	0.140	0.160		. 151	150	1150	.181		
Al	0.140	0.160		-149	191	:149	149		
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	Acce	pt/Reject					-		
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Date: 14-11 . 09	Date: /////24	
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Rev	Date	Change	Revised by	Approved
Α	06.09.26	New Issue	KJ/EC	
В	08.10.07	Dimension H removed	KJ/DD	
С	08.11.28	Dimension 'M' revised	KJ/EC \	1.
D	11.01.17	Note added to Dim I	KJ 9	SK



